



Dart Aerospace Ltd.  
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D5413-1  
Job Sheet 170198

Accounting Job RD17-1027-01



Part No: D5413-1

Job Qty: 24 ea

Part Name: Crosstube Support



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/11/18

Job Tracking No:

Due Date: 1/18/18

Created By: Mario Poulin

Type: R+D

Description:

Note: DWG D5413 REV A IPP Rev:A RQ 16.10.06 Verified by DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                        |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation     | 24 Ea  |            | 1/15/18  | 0.00      | 0.00    | Start Up Machining-4  |           | 1/18-02-05     |
| 100   | Bandsaw                | 24 pcs |            | 1/15/18  | 0.00      | 0.00    | Bandsaw1              |           | 1/18-02-05     |
| 110   | CNC Vertical Machining | 24 pcs |            | 1/15/18  | 0.00      | 0.33    | HAAS1-1               |           | 1/18-02-05     |
| 120   | QC                     | 24 pcs |            | 1/15/18  | 0.00      | 0.00    | QC2 Machining-4       |           | 1/18-02-05     |
| 122   | Mill Conv              | 24 pcs |            | 1/17/18  | 0.00      | 50.40   | Mill Conv 1           |           | 1/18-02-05     |
| 123   | QC                     | 24 pcs |            | 1/17/18  | 0.00      | 0.00    | QC2 Machining-4       |           | 1/18-02-05     |
| 130   | QC                     | 24 pcs |            | 1/17/18  | 0.00      | 0.00    | QC8 Machining-4       |           | 1/18-02-05     |
| 140   | HandFinish             | 24 pcs |            | 1/17/18  | 0.00      | 4.59    | HandFinish1           |           | SA 18-05-18    |
| 150   | SprayPaint             | 24 pcs |            | 1/18/18  | 0.00      | 6.00    | Spray Paint           |           | ADAM 20 2018   |
| 160   | QC                     | 24 pcs |            | 1/18/18  | 0.00      | 0.00    | QC14                  |           | 11 MAY 24 2018 |
| 170   | Packaging              | 24 pcs |            | 1/18/18  | 0.00      | 0.00    | Packaging3-2          |           | 9 MAY 24 2018  |
| 180   | QC21-SA                | 24 Ea  |            | 1/18/18  | 0.00      | 0.00    | QC21                  |           | 21 MAY 25 2018 |

Part Op 100 - Cut Blanks 5.00" long

Descriptions: 110 - Machine as per Folio FB504 Folio Rev: \_\_\_\_\_ Dwg Rev: \_\_\_\_\_ -Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

122 - Manufacture as per dwg

123 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - \*\*\*MASK AS PER DWG NOTE 8\*\*\* PRIME AS PER DWG QSI005 4.2.1.3.3 BATCH: 138408 PAINT AS

PER DWG QSI005 4.2.2.4 BATCH: 138819

160 - QC14- Inspect Spray Paint

170 - Identify as per dwg & Stock Location: \_\_\_\_\_

180 - QC21- Final Inspection - Work Order Release

5036066

### Job Allocations

| Operation             | Component Part       | Required | Inventory | Allocated | Std Qty |
|-----------------------|----------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | M6061T6B2.500X04.500 | 10       | 7         | 0         | 0       |

### Part Specifications

Specifications could not be found.

DQA:

Date: 19 Jun 2019

WOP 19 Jun 2019



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed Date: JUN 19 2019

Work Order update only

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                                                                                                               |  |                                                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Work Order: <u>170 198</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | DISPOSITION                                                                                                                   |  | AGAINST DEPARTMENT/PROCESS                                                                                                                                          |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |
| Part No. <u>DS413-1</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  | Rework <input checked="" type="checkbox"/><br>Scrap <input checked="" type="checkbox"/><br>Use-as-is <input type="checkbox"/> |  | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input checked="" type="checkbox"/><br>Composite <input type="checkbox"/>    |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |
| NCR No. <u>19-7185</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Suspected Unapproved                                                                                                          |  | Skid-tube <input type="checkbox"/><br>Machining <input checked="" type="checkbox"/><br>Thermoforming <input type="checkbox"/><br>Large Fab <input type="checkbox"/> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |
| Date: <u>18-02-05</u>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  | Step #: <u>110</u>                                                                                                            |  | QTY Effective: <u>1</u>                                                                                                                                             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |                                                                                                                               |  |                                                                                                                                                                     |  | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                       |  |
| The center Bore was not centered on the part                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |  |                                                                                                                               |  |                                                                                                                                                                     |  | Scrap & Replace<br>B S036066                                                                                                                                                                                                                                                                                                                                                                                                      |  |
| Root Cause                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                                                                                                                               |  |                                                                                                                                                                     |  | Completed By<br>20 18-02-05<br>9-88                                                                                                                                                                                                                                                                                                                                                                                               |  |
| Environment <input type="checkbox"/><br>Design <input type="checkbox"/><br>Doc/Data <input type="checkbox"/><br>Equip/Tooling <input type="checkbox"/><br>Handling/Pre <input type="checkbox"/><br>Material <input type="checkbox"/><br>Internal Transport <input type="checkbox"/><br>Tribal Knowledge <input type="checkbox"/><br>LOA <input type="checkbox"/><br>Substation <input type="checkbox"/><br>Past Expiry Date <input type="checkbox"/><br>Misidentified <input type="checkbox"/>                                     |  |                                                                                                                               |  |                                                                                                                                                                     |  | Lead hand / Supervisor Approval Verification<br>20 18-02-05                                                                                                                                                                                                                                                                                                                                                                       |  |
| No Re-verification <input type="checkbox"/><br>Operator <input type="checkbox"/><br>Offset/Setup <input checked="" type="checkbox"/><br>Supplier <input type="checkbox"/><br>Training <input type="checkbox"/><br>Use for Testing <input type="checkbox"/><br>Poor Information <input type="checkbox"/><br>Rushing <input type="checkbox"/><br>Product Improvement <input type="checkbox"/><br>Process Improvement <input type="checkbox"/><br>Manufacturing Process <input type="checkbox"/><br>Past Due <input type="checkbox"/> |  |                                                                                                                               |  |                                                                                                                                                                     |  | QC / QA Coordinator Approval<br>20 18-02-05                                                                                                                                                                                                                                                                                                                                                                                       |  |
| Pressure/Forced <input type="checkbox"/><br>Bending <input type="checkbox"/><br>Centre Not Concentric <input checked="" type="checkbox"/><br>Cracks <input type="checkbox"/><br>Crimp/Kink/Ripple/Wave <input type="checkbox"/><br>Cuffs <input type="checkbox"/><br>Crushing <input type="checkbox"/><br>Heat Treat <input type="checkbox"/><br>Wave/Twist in Tube <input type="checkbox"/><br>Marks/Chatter <input type="checkbox"/>                                                                                             |  |                                                                                                                               |  |                                                                                                                                                                     |  | Positioned Wrong <input type="checkbox"/><br>Outside Dimensions <input type="checkbox"/><br>Over/Under tolerance <input type="checkbox"/><br>Part Incorrect <input type="checkbox"/><br>Part Lost/Missing <input type="checkbox"/><br>Part Moved <input type="checkbox"/><br>Drawing <input type="checkbox"/><br>Finish <input type="checkbox"/><br>Misread <input type="checkbox"/><br>Turning Sequence <input type="checkbox"/> |  |
| OTHER: <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                                                                                                                               |  |                                                                                                                                                                     |  |                                                                                                                                                                                                                                                                                                                                                                                                                                   |  |

